IN THE CLAIMS

Please amend the claims as follows:

Claim 1 (Currently Amended): A die set for press forming a metal sheet, comprising:

a punch; and

a die,

wherein a clearance CL2 between the punch and the die corresponding to a site to be formed immediately after an initial stage of press forming and a clearance CL1 between the punch and the die corresponding to a site to be formed in the initial stage of press forming are set so as to satisfy the following expressions (1) and (2), respectively:

$$0.8 \times t \leq CL1 \leq 1.2 \times t \qquad (1)$$

$$CL2 \geq CL1 + t \qquad (2)$$

where t denotes a thickness of the metal sheet to be formed,

wherein a convex portion extending toward the die is formed at a top part area of the punch corresponding to a site to be formed at the initial stage of forming.

Claim 2 (Original) The die set for press forming a metal sheet according to claim 1, further comprising a forming jig which moves in synchronism with the die while keeping a relative position to the die during forming, and forms a vertical wall portion of the metal sheet, wherein in the forming jig, a clearance CL4 between the forming jig and the die in the vicinity of a die shoulder of the die is set so as to be wider than a clearance CL3 between the forming jig and the die in a forming area other than the vicinity of the die shoulder of the die.

Claim 3 (Currently Amended) ~~The die set for press forming a metal sheet according to claim 2~~ A die set for press forming a metal sheet, comprising:

a punch;

a die, wherein a clearance CL2 between the punch and the die corresponding to a site to be formed immediately after an initial stage of press forming and a clearance CL1 between the punch and the die corresponding to a site to be formed in the initial stage of press forming are set so as to satisfy the following expressions (1) and (2), respectively:

$$0.8 \times t \leq CL1 \leq 1.2 \times t \quad (1)$$

$$CL2 \geq CL1 + t \quad (2)$$

where t denotes a thickness of the metal sheet to be formed; and

a forming jig which moves in synchronism with the die while keeping a relative position to the die during forming, and forms a vertical wall portion of the metal sheet, wherein in the forming jig, a clearance CL4 between the forming jig and the die in the vicinity of a die shoulder of the die is set so as to be wider than a clearance CL3 between the forming jig and the die in a forming area other than the vicinity of the die shoulder of the die,

wherein the clearances CL3 and CL4 are set so as to satisfy the following expressions (3) and (4), respectively:

$$0.8 \times t \leq CL3 \leq 1.2 \times t \quad (3)$$

$$CL4 \geq CL3 + t \quad (4)$$

where t denotes the thickness of the metal sheet to be formed.

Claim 4 (Currently Amended): A press forming method of a metal sheet~~, comprising press forming the metal sheet using the~~ using a die set ~~for press forming according to claim 1~~ comprising a punch and a die, the method comprising the steps of:

introducing the punch into the die in an initial stage of press forming;

continuing to introduce the punch into the die after the initial stage of press forming; and

providing a clearance CL2 between the die and a portion of the punch which enters the die immediately after an initial stage of press forming, and providing a clearance CL1 between the die and a portion of the punch which enters the die in the initial stage of press forming, wherein CL1 and CL2 are set so as to satisfy the following expressions (1) and (2), respectively:

$$0.8 \times t \leq CL1 \leq 1.2 \times t \quad (1)$$

$$CL2 \geq CL1 + t \quad (2)$$

where t denotes a thickness of the metal sheet to be formed.

Claim 5 (Currently Amended): A die set for press forming a metal sheet, and manufacturing a formed product ~~having an inclined vertical wall portion~~, comprising:

a punch;

a die; and

a forming jig mounted to move ~~which moves~~ in synchronism with the die while keeping a relative position to the die during forming, ~~and forms the inclined vertical wall portion of the metal sheet,~~

wherein in the forming jig, a clearance CL4 between the forming jig and the die in the vicinity of a die shoulder of the die is set so as to be wider than a clearance CL3 between the forming jig and the die in a forming area other than the vicinity of the die shoulder of the die.

Claim 6 (Currently Amended): ~~The die set for press forming a metal sheet according to claim 5~~ A die set for press forming a metal sheet, and manufacturing a formed product having an inclined vertical wall portion, comprising:

a punch;

a die; and

a forming jig which moves in synchronism with the die while keeping a relative position to the die during forming, and forms the inclined vertical wall portion of the metal sheet,

wherein in the forming jig, a clearance CL4 between the forming jig and the die in the vicinity of a die shoulder of the die is set so as to be wider than a clearance CL3 between the forming jig and the die in a forming area other than the vicinity of the die shoulder of the die,

wherein the clearances CL3 and CL4 are set so as to satisfy the following expressions (3) and (4), respectively:

$$0.8 \times t \leq CL3 \leq 1.2 \times t \qquad (3)$$

$$CL4 \geq CL3 + t \qquad (4)$$

where t denotes the thickness of the metal sheet to be formed.

Claim 7 (Original): A press forming method of a metal sheet, comprising press forming the metal sheet using the die set for press forming according to claim 5.

Claim 8 (New): The die set for press forming a metal sheet according to claim 5, wherein the die has an inclined vertical wall to form an inclined vertical wall portion of the metal sheet.